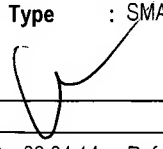
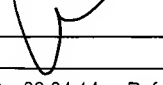


ASAP

Dart Aerospace Ltd.

Date: Friday, 23/11/2007 7:43:03 AM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : MOUNTING ANGLE
Job Number : 35968	
Estimate Number : 10412	
P.O. Number : N/A	Part Number : D2416
This Issue : 23/11/2007 S.O. No. : N/A	Drawing Number : D2416 REV. B
Prsht Rev. : NC	Project Number : N/A
First Issue : MA Type : SMALL / MED FAB	Drawing Revision : B
Previous Run : 26907	Material : N/A
Written By : 	Due Date : 30/11/2007 Qty: 20 Um: Each
Checked & Approved By : 	
Comment : Est:C 03.04.14 Reformat; Incorporated D2292; D2375-3-08-106; D2403 - D2417 KJ/RF	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0	M2024T3S063	2024-T3 .063 sheet
-----	-------------	--------------------



Comment: Qty.: 0.0255 sf(s)/Unit Total : 0.5103 sf(s)
 Material: 2024-T3 (QQ-A-250/4) 0.063" thick
 (M2024T3S.063) Batch: 101022
 Identify for D2416

HB 07-11-26

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET
 1-Cut as per Dwg D2416
 Dwg Rev: B
 Prog Rev: B

HB 07-11-26

(20)

2-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

HB 07-11-26

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

6 A11126 (x20) (only)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1
 Deburr Stack

HB 07/11/26 (20)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: D Date: 07/11/28
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Drawing Name: MOUNTING ANGLE

Part Number: D2416



Description :

...the ...

[illegible]

Bend as per Dwg D2416

07/11/27 (20)

[illegible]

74/77 20 corantes

Abstract

[illegible]

Acid etch and Alodine as per QSI 005 4.1

MS 07-11-28 (20)

[illegible]

BR 07-11-28

[illegible]

Identify and Stock

Location:

ST32 *[Signature]* AS 07/11/29 X20

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/11/28

1. The first step is to identify the key components of the system. This includes understanding the hardware, software, and data involved.

2. The second step is to define the requirements. This involves determining what the system is intended to do and what it must be able to handle.

3. The third step is to design the system. This includes creating a detailed plan of how the system will be built and how it will be tested.

4. The fourth step is to implement the system. This involves building the system according to the design and testing it to ensure it meets the requirements.

5. The fifth step is to maintain the system. This involves monitoring the system's performance and making any necessary adjustments or updates.

u 5/11/29

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

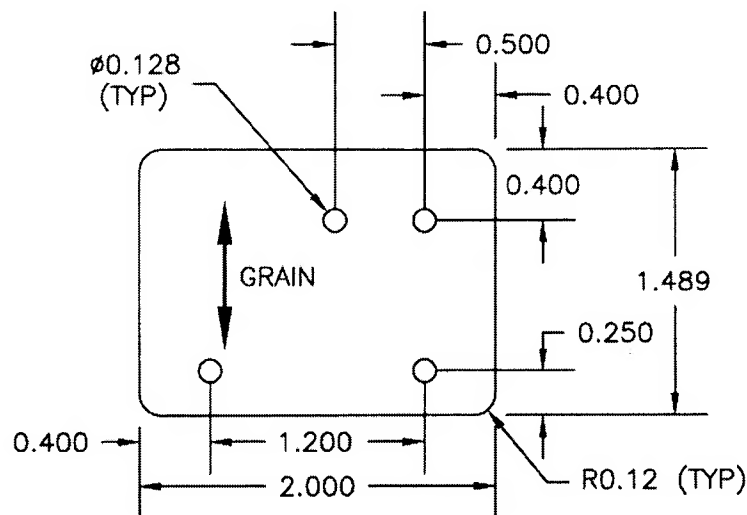
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

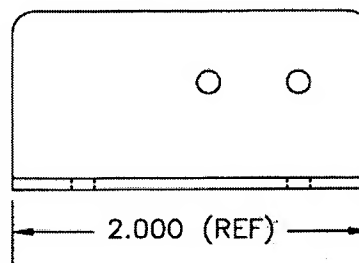
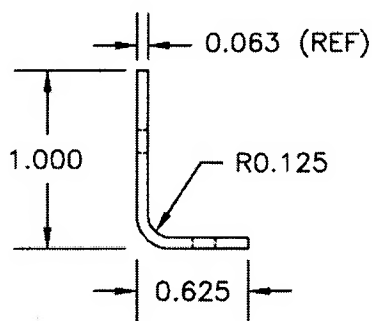


DESIGN BW	DRAWN BY 	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D2416	REV. B SHEET 1 OF 1
DATE 03.04.09		TITLE MOUNTING ANGLE	SCALE 1:1
A	95.04.06	NEW ISSUE	
B	03.04.09	ADDED $\phi 0.128$ & FLAT PATTERN	

RELEASED
03.05.07



FLAT PATTERN



BEND DETAIL

NOTES:

- 1) MATERIAL: 2024-T3/T3511 0.063" THICK PER QQ-A-250/4 (REF DART SPEC: M2024T3S.063)
- 2) FINISH: ACID ETCH AND ALODINE AS PER DART QSI 005 4.1
- 3) DEBURR ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

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